

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002764**Date Inspected:** 02-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chih-Ming / An Qingxiang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG side and bottom panels and tower skin p**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA performed 10% verification Magnetic particle Testing (MT) on the following side to bottom panel joints: SEG-16A-008A and SEG-16A-007A. Both welds appeared to be compliant with AWS D1.5 2002 and the contract documents.

QA observed ZPMC personnel installing floor beam in the OBG fixture section FL2-1 and FL2-2 to FL1 south at PP-021 segment 3A east (SEG 14).

QA observed ZPMC qualified welding personnel perform SAW on SP-305 to SP-332 joint# SEG-024A-001 following the guide lines of WPS# WPS-B-T-2221-B-L2c-S-1. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 29.5 Amps: 520 Travel speed: 530mm/min

QA observed ZPMC qualified welding personnel perform SMAW tack welding on SP-747 to SP-509 joint# SEG-021A-008 following the guide lines of WPS# WPS-B-P-2211-B-U2-FCM. QC monitored the process continuously until completion. The welding parameters as measured with Quality Controls calibrated instruments

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appeared to be in conformance with the posted WPS's and were as follows:

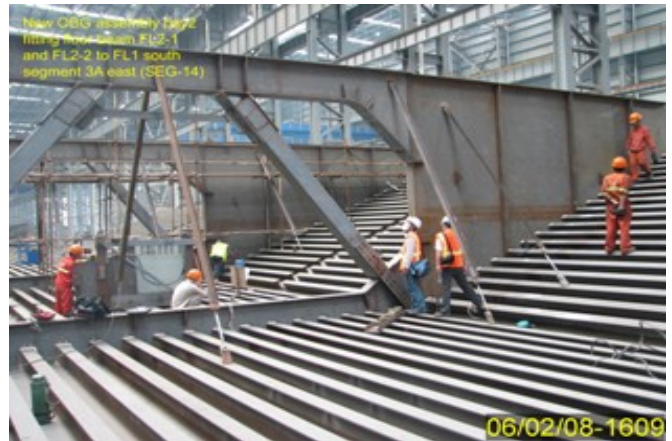
Volts: 22 Amps: 170 Travel speed: 104mm/min

Other general observations include ZPMC personnel grinding side and bottom panels and weld bevel prep.

New Tower Bay 2

General observations in the New Tower bays include weld bevel preparation, flame straightening, CNC parts cutting, hole drilling and grinding.

No welding was performed in this bay during the time QA was present.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
